

Work
Decem
Item II
Revisio
Item N
Start D
Requir
Refere

Appro

Sequen
Work C

120

*12

QC

Quality C

130

*13

HandFin

Hand Fin

140

*14

QC

Quality C

Work Order ID 139967

December 15, 2015 3:02:38 PM

139967

Page 1

Item ID: E4706-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support Assembly

Stop

NS2

Start Date: 12/15/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/4/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

SA

Date: 20151215

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

E4706

B

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Purchasing

Issue P/O:

30760

Supplier: WEJAY.

Machine as per Dwg E4706-1

Conformity sheet required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

6

FEB 22 2016

Work Order ID 139967

December 15, 2015 3:02:38 PM

139967

Page 4

Item ID: E4706-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support Assembly

Start Date: 12/15/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/4/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

144

QC5- Inspect part completeness to step on W/O

0.00

144

QC

Memo

0.00

Quality Control

(6)

MAR 11 2016

150

Identify as per dwg & Stock Location **PP 139963**

0.00

150

Packaging

Memo

0.00

Packaging

6DAS
6
9-89

MAR 11 2016

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.01

Quality Control

16/1/14

MAR 11 2016

MS

December 15, 2015 3:02:45 PM

139967

F4706-041

Required Date: 3/4/2016

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

0.0000

139967

**

DAS
6
9-89

FEB 22 2016

4.0000

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133855

554

DAS
6
9-89

Loc Code

△

 Δ

28.0000

e

DAS
6
9-89

552

Loc Code

28

4

24

14.0000

6

582

DAS
6
9-89

Loc Code

14

9

5

MAR 08 2016

Picklist Print

December 15, 2015 3:02:45 PM

Page 2

Work Order ID: 139967

139967

Parent Item: E4706-041

F4706-041

Parent Item Name: Support Assembly

Start Date: 12/15/2015

Required Date: 3/4/2016

Start Qty: 6.00

Required Qty: 6.00

NAS77A8-031

Purchased

No

Each

2.0000

6

NAS77A8-031

134029X4

DAS

Bushing

6

9-89

554

Location

Loc Qty

Loc Code

ST260

2

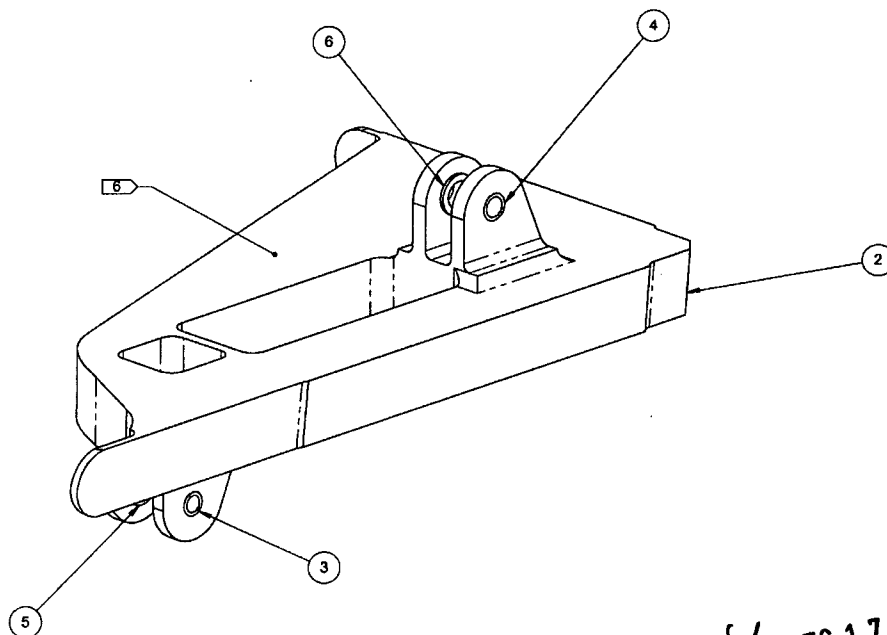
M128749

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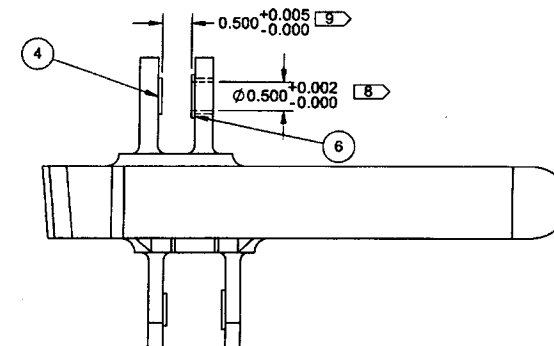
2

MAR 08 2016

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	E4706-041	SUPPORT ASSEMBLY
2	1	E4706-1	SUPPORT BRACKET
3	1	NAS77A5-025	BUSHING
4	1	NAS77A6-031	BUSHING
5	1	NAS77A7-025	BUSHING
6	1	NAS77A8-031	BUSHING



E4706-041 SUPPORT ASSEMBLY



**E4706-041 SUPPORT ASSEMBLY
SUPPLEMENTARY VIEW**

RELEASED

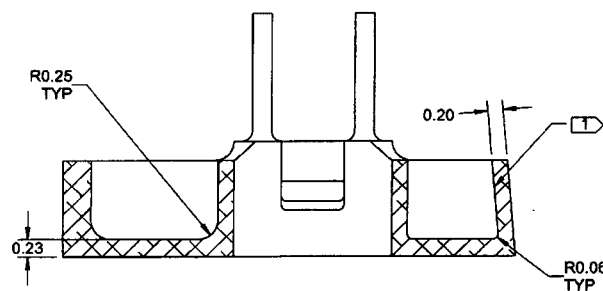
2014 NOV 24
ECN 14-639

DEC 17 2015
W10:139967

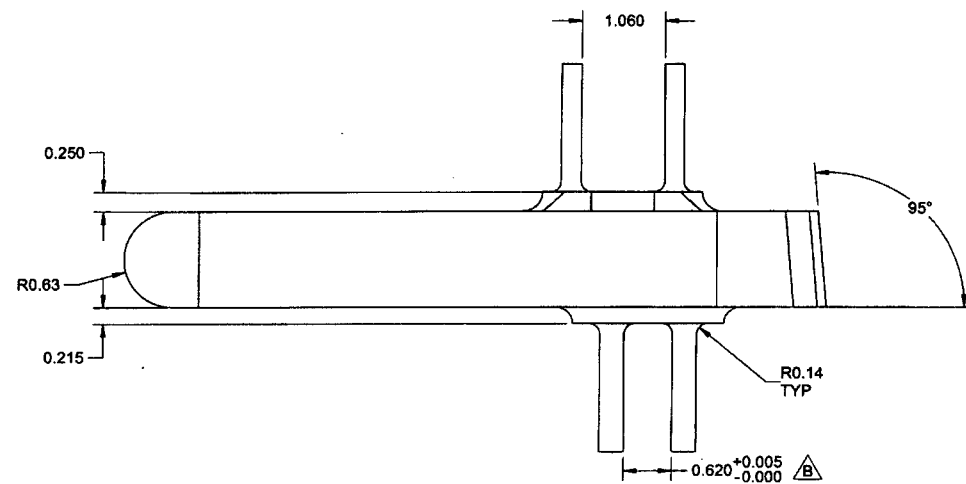
B	ADDED RIGHT VIEW TO SHEET 1 ZN B2-1, CHANGED TOLERANCE ZN B2-3	CC	14.11.11
A	NEW ISSUE	DC	12.08.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	CC		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	21	E4706	SHEET 1 OF 5
APPROVED	21	TITLE	SCALE
DE APPR.	21	SUPPORT ASSEMBLY	NTS
DATE	14.11.11	COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.93 lbs
- 8) REAM BUSHING (ITEM 6), AS REQUIRED TO MAINTAIN TOLERANCES
- 9) MACHINE BUSHING FACES (ITEMS 4 AND 6) AS REQUIRED TO MAINTAIN TOLERANCES



SECTION A-A
(ROTATED 90°)
B5-2

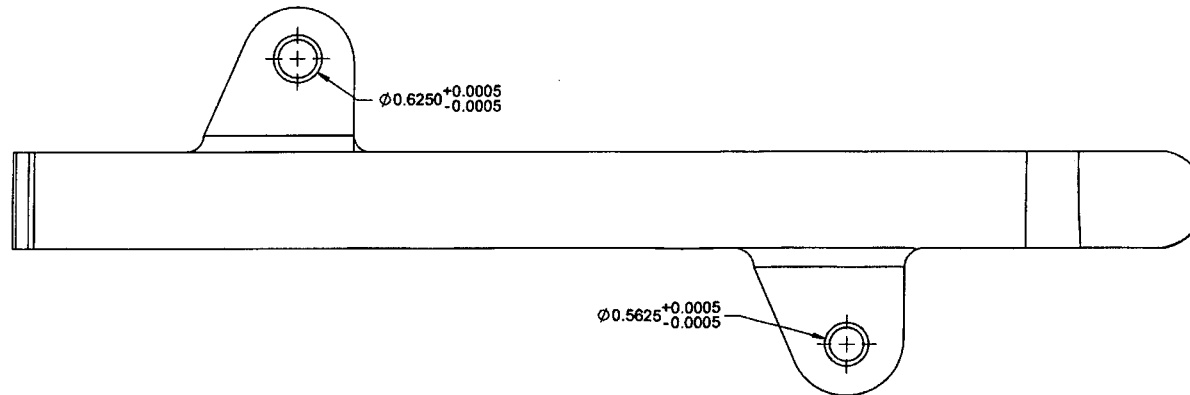
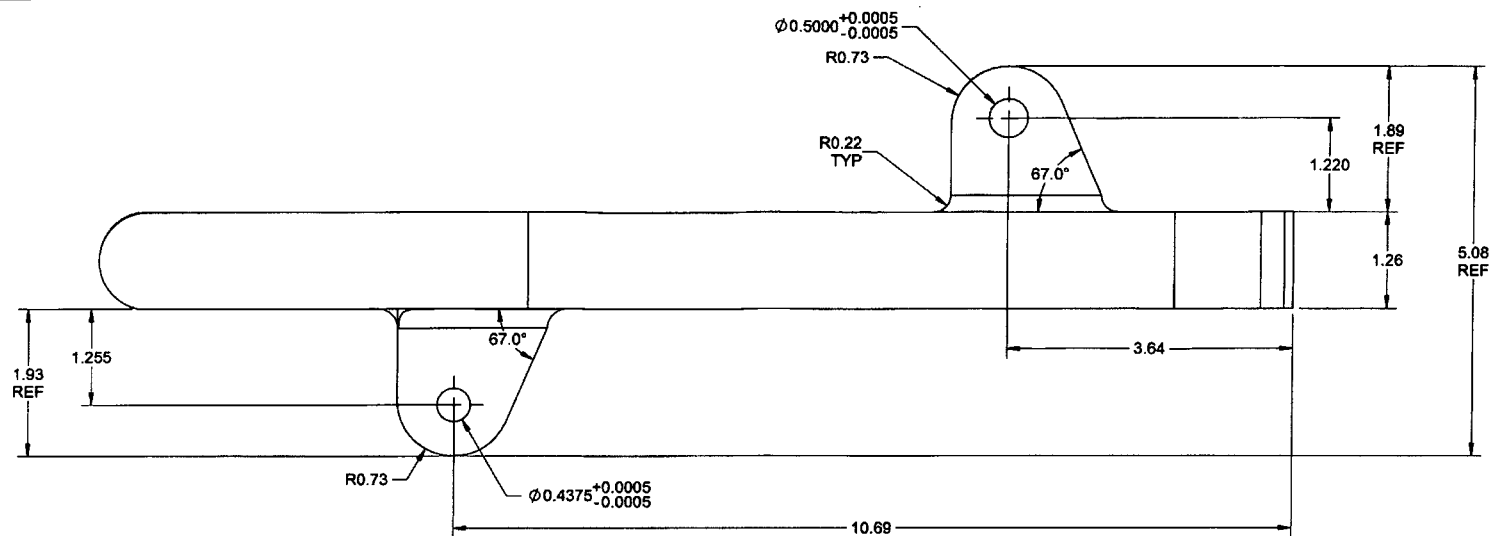


E4706-1 SUPPORT BRACKET
RIGHT VIEW

RELEASED
2014 NOV 24 *dp*

NOTES:
1) CREATE RELIEF PARALLEL TO OUTSIDE FACE AT LOCATION SHOWN

DESIGN	<i>BC</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	<i>CC</i>		
CHECKED	<i>VS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>4/</i>	E4706	SHEET 3 OF 5
APPROVED	<i>4/</i>	TITLE	SCALE
DE APPR.	<i>4/</i>	SUPPORT ASSEMBLY	NTS
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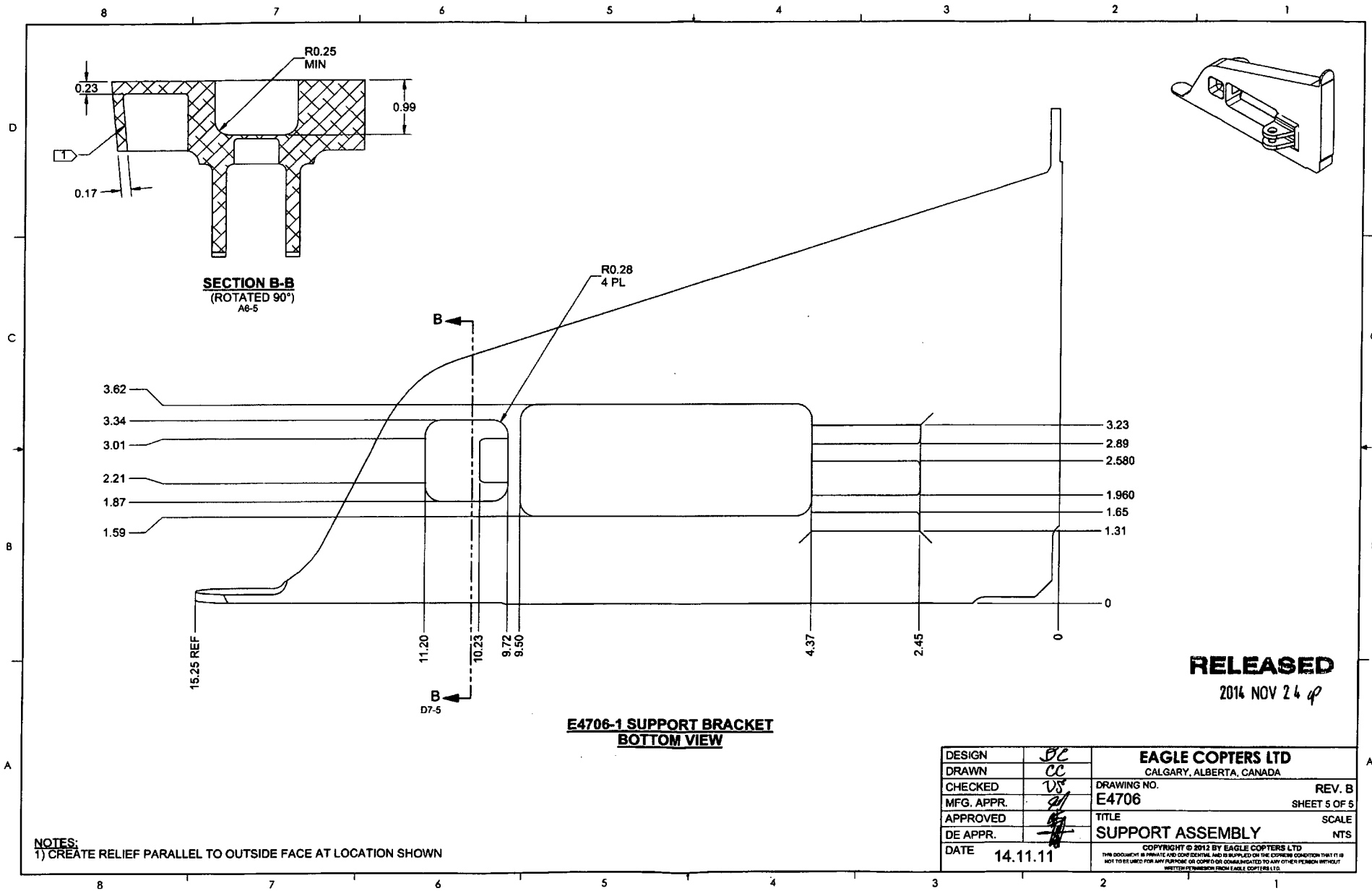


**E4706-1 SUPPORT BRACKET
SUPPLEMENTARY VIEWS**

RELEASED

2014 NOV 24

DESIGN	DC	EAGLE COPTERS LTD	
DRAWN	CC	CALGARY, ALBERTA, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	21	E4706	SHEET 4 OF 5
APPROVED	67	TITLE	SCALE
DE APPR.	67	SUPPORT ASSEMBLY	NTS
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Packing Slip 37729

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
 TEL: 613-384-1662 FAX: 613-384-2997
 www.wejay.com

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O

Part Assembly
 2000 1/2" x 1/2" x 1/2"
 11/16/15

INVOICE DATE	YOUR ORDER NO.	DATE ORDERED	SHIPPED VIA
		12/18/15	FEDEX
CUSTOMER CODE	PROV. LIC. NO.	Extra ☐ Exempt ☐	TERMS

QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION	UNIT PRICE	AMOUNT
6	—	6	1/2" x 1/2" x 1/2" (per drawing 11/15), Rev. 1		
6	—	6	1/2" x 1/2" x 1/2" (per drawing 11/15), Rev. 1		

Inspected and tested February 10, 2016

RELEASE NOTE

I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.

Inspection Supervisor *[Signature]* **WMP 03**
 FEB 16/16

G.S.T.
 P.S.T.

ORDER: COMPLETE ☐ PARTIAL ☐

TOTAL	
--------------	--

RECEIVED BY _____
 1.5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT PRIOR AUTHORIZATION



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30760**

Purchase Order Date 12/17/2015

PO Print Date 12/17/2015

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
DEC 18 2015

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	E4702-1P	Ladder	2/12/2016 Yes 2/12/2016		6.00 Each	\$1,895.00	\$11,370.00

AS PER DWG E4702 REV. A
B139966
MATERIAL SUPPLIED FROM WEJAY

Line Total: \$11,370.00

2	E4706-1P	Support Bracket	2/12/2016 Yes 2/12/2016	FN	6.00 Each	\$2,025.00	\$12,150.00
---	----------	-----------------	-------------------------------	----	--------------	------------	-------------

AS PER DWG E4706 REV. B
B139967
MATERIAL SUPPLIED FROM WEJAY

Line Total: \$12,150.00

PO Instructions: QUOTATION NO. WJ-8767

Note:

12/17/2015



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Feb. 16, 2016	
		P.O.# PO30760	
		WEJAY JOB# 37729	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
E4706-1P 'Support Bracket' B139967	6	Machined complete per drawing req'ts.	E4706 / rev. B
Note: 1) Material Test Cert. attached -ref. 'Constellium' Lot# 9332688 (Wejay TN# 31699-2). 2) Inspection / Test Reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith

Authorized Q.A. Signatory



CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

S
H
I
P

T
O

COPPER & BRASS-TMX DIVISION

5450 E HOME
FRESNO CA
93727
US

S
O
L
D

T
O

COPPER & BRASS

PO BOX 5116
SOUTHFIELD MI
48086
US

COPPER&BR 110375931 1800 INCLUSION Serial:20151227-0110375931 Pg 1of2

CUSTOMER PURCHASE ORDER NO. & ITEM
5400278344

Constellium ORDER NO.
154569

ALLOY	CLAD	TEMPER	GAUGE	WIDTH	LENGTH
7075		T351	5.0000 in 127.00 mm	60.5000 in 1,537 mm	144.5000 in 3,670 mm

ITEM ORDERED
SPEC PLATE, SAWED
MILL FINISH

CUSTOMER SPECIFICATION
AMS QQ-A-250/12A

PART NUMBER
ALFLR08960

B/L NUMBER
53491

DATE SHIPPED
12/28/2015

WT. SHIPPED
9180.000 LB

NO. OF PIECES
000002

GOVT. CONTRACT NO.

CERTIFICATION

"Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."
Constellium Rolled Products Ravenswood, LLC
859 Century Road
P.O. BOX 68
RAVENSWOOD, WV 26164 USA

Steve Good - Laboratory Manager

ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:

BSS-7055 REV B 2013 100% SONIC Class A
AMS 407BJ CHEMISTRY ONLY
AMS-STD-2154A 2012 TYPE1 CLASS A 100% SONIC MINUS DEADZONE
ASTM B209-14 CHEMISTRY ONLY

Load Details

Package	Net Lbs	Kg	Lot	Piece	Serial	Parent Lot
1001176393	4,580.000	2,077.451	9332688	01		
1001176394	4,580.000	2,077.451	9332688	02		

Lot: 9332688

Tensile Test (US)

Direction	Tests	Ultimate (KSI)		Yield (KSI)		Elongation (%)	
		Min	Max	Min	Max	Min	Max
LT	02	60.5	62	46.6	48.5	12	12

Tensile Test (SI)

Direction	Tests	Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)	
		Min	Max	Min	Max	Min	Max
LT	02	417	427	321	334	12	12

Conductivity % IACS MIN 41.1 MAX 41.1 % MS/M MIN 23.8 MAX 23.8



TN31699-2
Job# 37729
rec'd Jan 20/16



Constellium



CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

S
H
I
P

T
O

COPPER & BRASS-TMX DIVISION

5450 E HOME
FRESNO CA
93727
US

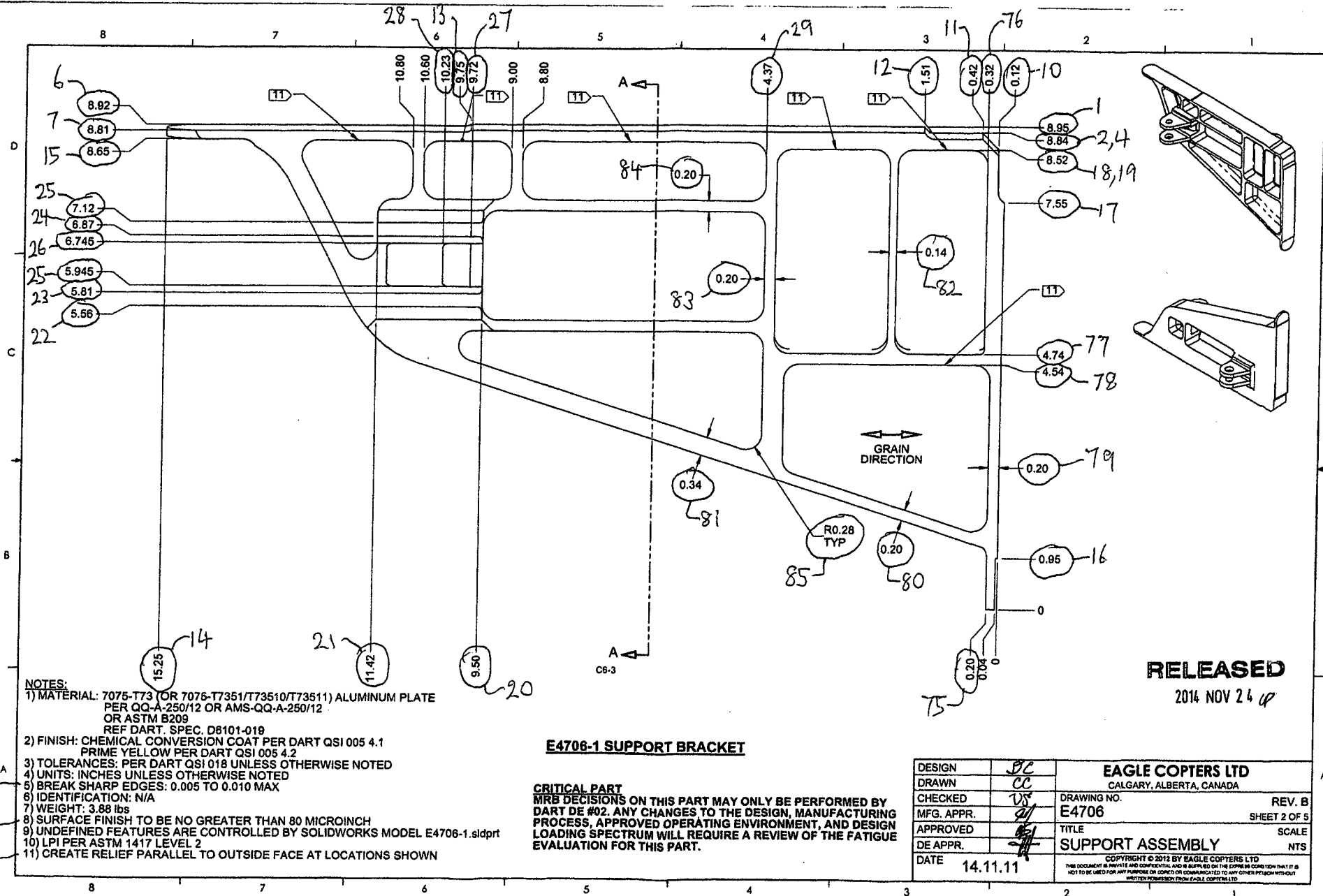
S
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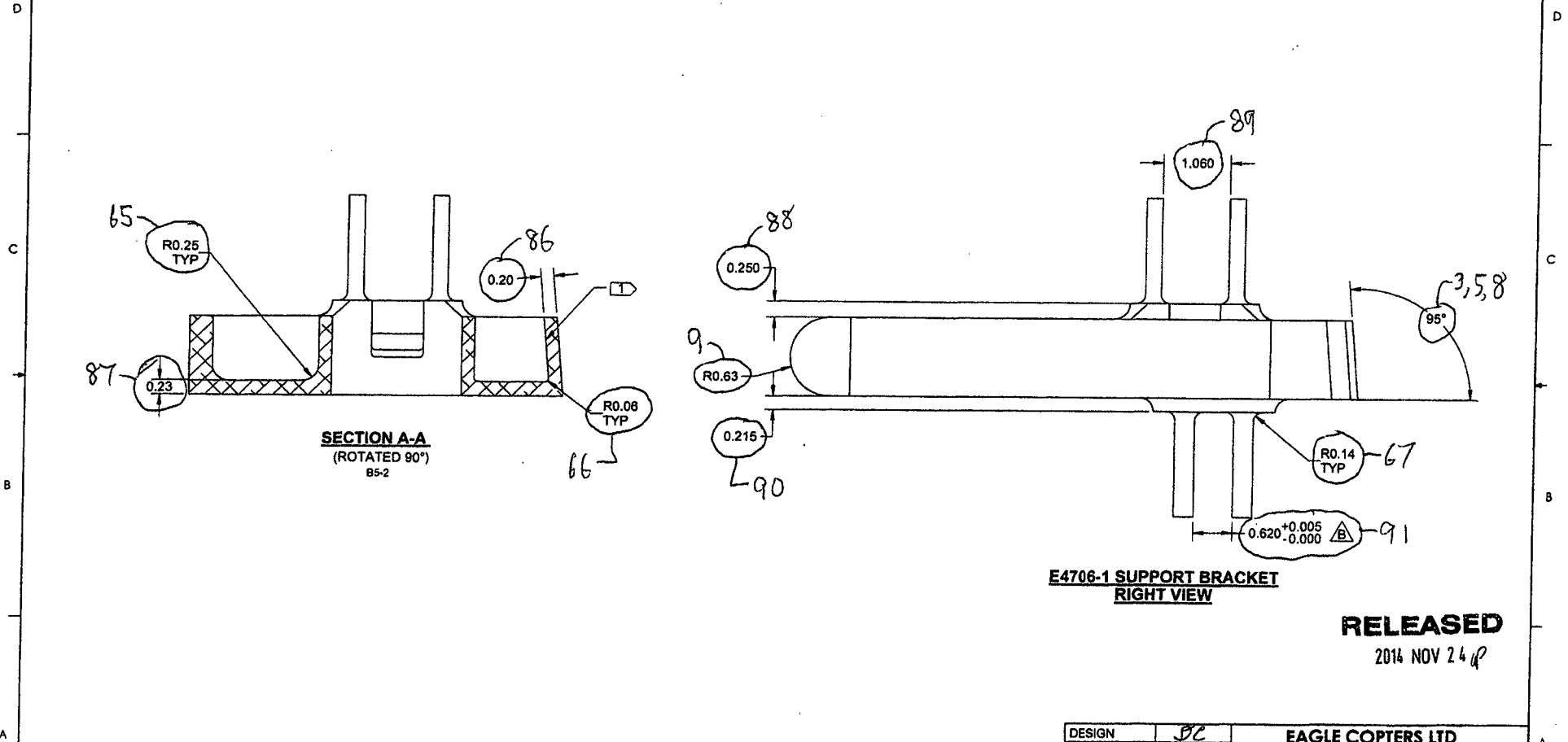
COPPER & BRASS

PO BOX 5116
SOUTHFIELD MI
48086
US

COPPER&BR		110375931		1800		INCLUSION		Serial:20151227-0110375931		Pg 2of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 5400278344						Constellium ORDER NO. 154569					
ALLOY 7075	CLAD	TEMPER T7351	GAUGE 5.00000 in 127.00 mm	WIDTH 60.50000 in 1,537 mm	LENGTH 144.50000 in 3,670 mm		CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Steve Good - Laboratory Manager				
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS QQ-A-250/12A											
PART NUMBER ALFLR08960			B/L NUMBER 53491		DATE SHIPPED 12/28/2015						
WT. SHIPPED 9160.000 LB		NO. OF PIECES 000002		GOVT. CONTRACT NO.							
Chemistry (Actual)											
	SI	FE	CU	MN	MG	CR	ZN	TI	ZR		
Core	0.05	0.15	1.47	0.03	2.60	0.23	5.59	0.02	0.01		
OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER											
All material contained in this lot was cast and manufactured in the USA											
THIS MATERIAL#S ORDERED GAUGEEXCEEDS THE SIZE RANGE OF APPLICABLE SPECIFICATIONS. THIS MATERIAL SHOULD NOT BE USED IN APPLICATIONS THAT REQUIRE CHARACTERISTICS EXPECTED IN THE SPECIFICATION(S) GAUGE RANGE; THEREFORE YOUR CAREFUL CONTROL IS NECESSARY TO PREVENT MISAPPLICATION.											
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. CHEMISTRY BY OES: ARKSPARK CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399 WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557 DUNS Number: 090570149; CAGE Code: 1YW19 Mercury is not a normal contaminant in aluminum alloys and neither mercury nor any of its compounds were utilized in the manufacture of our product. "END OF CERTIFICATION"											
P-860-155D REVISED: 10 2014											



8 7 6 5 4 3 2 1

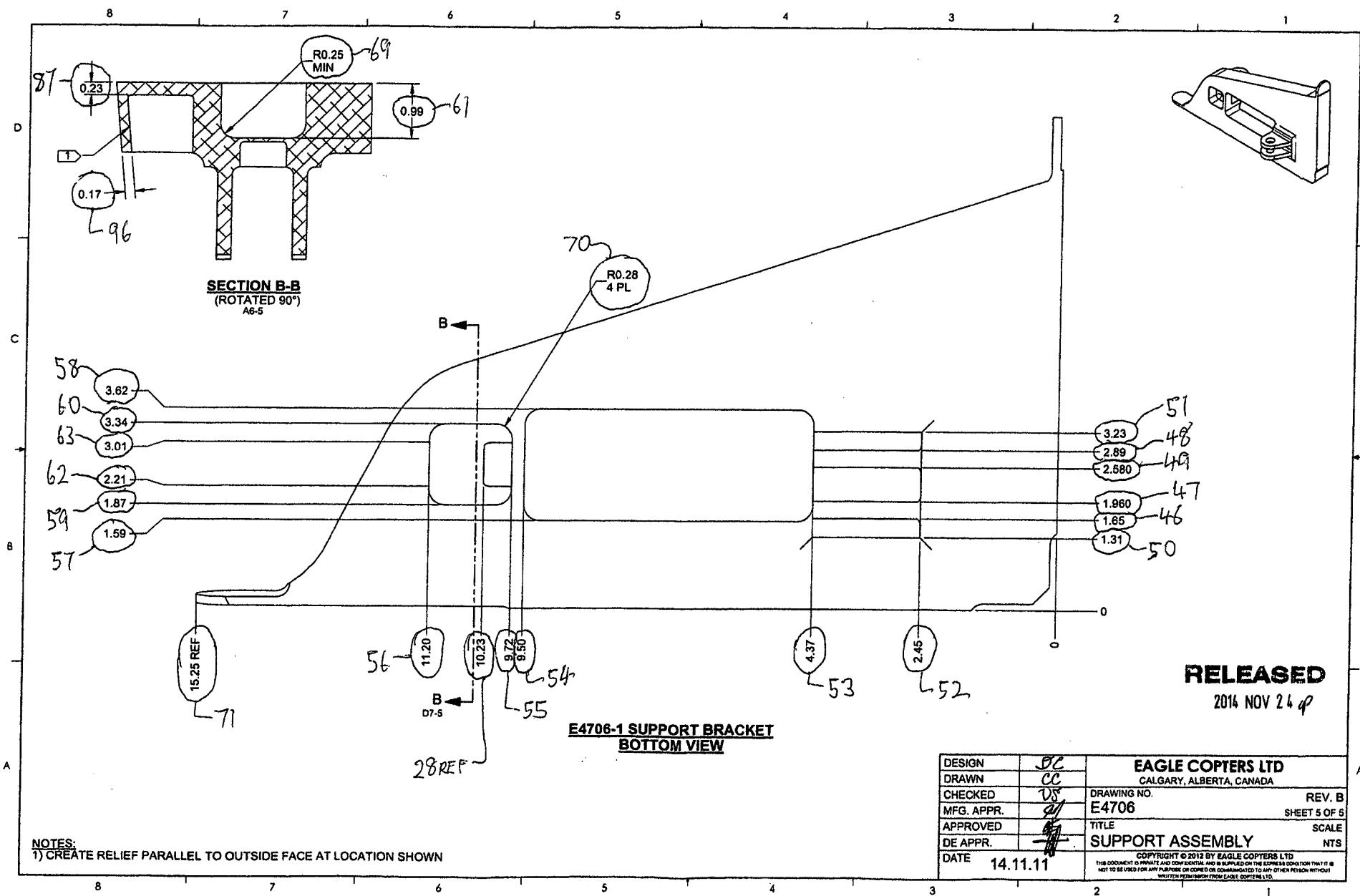


NOTES:
1) CREATE RELIEF PARALLEL TO OUTSIDE FACE AT LOCATION SHOWN

RELEASED
2014 NOV 24 P

DESIGN	DC	EAGLE COPTERS LTD	
DRAWN	CC	CALGARY, ALBERTA, CANADA	
CHECKED	DS	DRAWING NO.	REV. B
MFG. APPR.	91	E4706	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	NTS
DATE	14.11.11	COPYRIGHT © 2012 BY EAGLE COPTERS LTD	
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8 7 6 5 4 3 2 1





Customer Dart Aerospace Customer P.O. PO30760
 Drawing # E4706 Drawing rev B
 Part Number D4706-1 E.C.O. -
 Part Name Support Bracket Material Alum. Alloy 7075-T7351 per ASTM B209
 Serial # 001 Inspected by Cliff Smith
 Job # 37729 Signature:



Overall Result

All Characteristics: 64
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: Side 1

MATERIAL: 7075-T7351 PER ASTM B209
 REF. 'CONSTELLUM' LOT#9332688

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- >
☐ Datum Face 1 Flat ref	GDT Flat	0.0028	0.0000	0.0050		0.0028	
☐ 1 2_D2	Y	8.9460	8.9500	0.0300	-0.0300	-0.0040	-
☐ 2 2_D2	Y	-8.8353	-8.8400	0.0300	-0.0300	0.0047	
☐ 3 3_C1	A	95.0180	95.0000	0.5000	-0.5000	0.0180	
☐ 4 2_D2	Y	8.8304	8.8400	0.0300	-0.0300	-0.0096	-
☐ 5 3_C1	A	94.9992	95.0000	0.5000	-0.5000	-0.0008	-
☐ 6 2_D8	Y	8.9159	8.9201	0.0300	-0.0300	-0.0043	-
☐ 7 2_D8	Y	8.8068	8.8099	0.0300	-0.0300	-0.0031	-
☐ 8 3_C2	A	95.0103	95.0000	0.5000	-0.5000	0.0103	
☐ 9 3_C5	R	0.6301	0.6300	0.0300	-0.0300	0.0001	
☐ 10 2_D2	X	-0.1144	-0.1200	0.0300	-0.0300	0.0056	
☐ 11 2_D3	X	-0.4149	-0.4200	0.0300	-0.0300	0.0051	
☐ 12 2_D3	X	-1.5040	-1.5100	0.0300	-0.0300	0.0060	
☐ 13 2_D6	X	-9.7485	-9.7500	0.0300	-0.0300	0.0015	
☐ 14 2_B8	ResEle	-15.2488	-15.2500	0.0300	-0.0300	0.0012	
☐ 15 2_D8	Y	8.6555	8.6500	0.0300	-0.0300	0.0055	
☐ 16 2_B2	Y	0.9534	0.9500	0.0300	-0.0300	0.0034	
☐ 18 2_D2	Y	8.5229	8.5200	0.0300	-0.0300	0.0029	
☐ 19 2_D2	Y	8.5230	8.5200	0.0300	-0.0300	0.0030	
☐ 20 2_B6	X	-9.4989	-9.5000	0.0300	-0.0300	0.0011	
☐ 21 2_B6	X	-11.4184	-11.4200	0.0300	-0.0300	0.0016	
☐ 22 2_C8	Y	5.5633	5.5600	0.0300	-0.0300	0.0033	
☐ 23 2_C8	Y	5.8137	5.8100	0.0300	-0.0300	0.0037	
☐ 24 2_D8	Y	6.8734	6.8700	0.0300	-0.0300	0.0034	
☐ 25 2_D8	Y	7.1235	7.1200	0.0300	-0.0300	0.0035	
☐ 25 2_C8	Y	5.9440	5.9450	0.0100	-0.0100	-0.0010	-
☐ 26 2_D8	Y	6.7435	6.7450	0.0100	-0.0100	-0.0015	-
☐ 27 2_D6	X	-9.7219	-9.7200	0.0300	-0.0300	-0.0019	-
☐ 28 2_D6	X	-10.2384	-10.2300	0.0600	-0.0600	-0.0084	-
☐ 29a 2_D4	X	-4.3624	-4.3700	0.0300	-0.0300	0.0076	
☐ 29b 2_D4	X	-4.3634	-4.3700	0.0300	-0.0300	0.0066	
☐ 29c 2_D4	X	-4.3628	-4.3700	0.0300	-0.0300	0.0072	



Part Number D4706-1

Serial # 001

Time 2:56:52 pm

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
☐ 23 Perp to body surf ref	GDT Perp	0.0010	0.0000	0.0050		0.0010	└
☐ 24 Parallel to 23 ref	GDT Par	0.0014	0.0000	0.0050		0.0014	└
☐ 30a 3_C8	Z	-1.0340	-1.0400	0.0300	-0.0300	0.0060	└
☐ 30b 3_C8	Z	-1.0352	-1.0400	0.0300	-0.0300	0.0048	└
☐ 30c 3_C8	Z	-1.0349	-1.0400	0.0300	-0.0300	0.0051	└
☐ 30d 3_C8	Z	-1.0351	-1.0400	0.0300	-0.0300	0.0049	└
☐ 30e 3_C8	Z	-1.0343	-1.0400	0.0300	-0.0300	0.0057	└
☐ 30f 3_C8	Z	-1.0337	-1.0400	0.0300	-0.0300	0.0063	└
☐ 30g 3_C8	Z	-1.0363	-1.0400	0.0300	-0.0300	0.0037	└
☐ 31 4_C5	D	0.4375	0.4375	0.0005	-0.0005	0.0000	-
☐ 32 4_C4	X	-10.6928	-10.6900	0.0300	-0.0300	-0.0028	-
☐ 33 4_A4	D	0.5622	0.5625	0.0005	-0.0005	-0.0003	—
☐ 34 4_C4	X	-10.6925	-10.6900	0.0300	-0.0300	-0.0025	-
☐ 35 4_C6	R	0.7254	0.7300	0.0300	-0.0300	-0.0046	-
☐ 36 4_C8	ResEle	1.9228	1.9300	0.0300	-0.0300	-0.0072	-
☐ 37 4_C6	A	67.0168	67.0000	0.5000	-0.5000	0.0167	└
☐ 77 2_C2	Y	4.7396	4.7400	0.0300	-0.0300	-0.0004	-
☐ 78 2_C2	Y	4.5404	4.5400	0.0300	-0.0300	0.0004	└
☐ 79 2_B2	3d Dist	0.1970	0.2000	0.0300	-0.0300	-0.0030	-
☐ 80 2_B3	3d Dist	0.1984	0.2000	0.0300	-0.0300	-0.0016	-
☐ 81 2_B4	3d Dist	0.3442	0.3448	0.0300	-0.0300	-0.0007	-
☐ 82 2_C3	3d Dist	0.1371	0.1400	0.0300	-0.0300	-0.0029	-
☐ 83 2_C4	3d Dist	0.1975	0.2000	0.0300	-0.0300	-0.0025	-
☐ 84 2_D4	3d Dist	0.1982	0.2000	0.0300	-0.0300	-0.0018	-
☐ 86 3_C6	3d Dist	0.1988	0.2000	0.0300	-0.0300	-0.0012	-
☐ 88 3_C5	Z	0.2548	0.2500	0.0300	-0.0300	0.0048	└
☐ 89 3_C2	CartDist	1.0592	1.0600	0.0100	-0.0100	-0.0008	-
☐ 92 4_D2	Z	1.2564	1.2550	0.0100	-0.0100	0.0014	└
☐ 93 4_D2	Z	1.2554	1.2550	0.0100	-0.0100	0.0004	└
☐ 96 5_D8	3d Dist	0.1693	0.1692	0.0300	-0.0300	0.0001	└



Customer Dart Aerospace Customer P.O. PO30760
 Drawing # E4706 Drawing rev B
 Part Number E4706-1 E.C.O. -
 Part Name Support Bracket Material Alum. Alloy 7075-T7351 per ASTM B209
 Serial # 37729-001 Inspected by Cliff Smith
 Job # 37729 Signature:



Overall Result

All Characteristics: 36
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: Side 2

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- >
☐ 38 4_D2	Z	-1.2586	-1.2600	0.0300	-0.0300	0.0014	-
☐ top and bott surfs Parallel ref	GDT Par	0.0033	0.0000	0.0100		0.0033	-
☐ 39 4_B6	D	0.6250	0.6250	0.0005	-0.0005	0.0000	-
☐ 40 4_C3	X	-3.6380	-3.6400	0.0300	-0.0300	0.0020	-
☐ 41 4_D4	D	0.4998	0.5000	0.0005	-0.0005	-0.0002	-
☐ 42 4_C3	X	-3.6384	-3.6400	0.0300	-0.0300	0.0016	-
☐ 42 4_D4	R	0.7268	0.7300	0.0300	-0.0300	-0.0032	-
☐ 43 4_D2	ResEle	1.8935	1.8900	0.0300	-0.0300	0.0035	-
☐ 44 4_D3	A	67.0266	67.0000	0.5000	-0.5000	0.0266	-
☐ 45 4_D2	ResEle	5.0773	5.0800	0.0300	-0.0300	-0.0027	-
☐ 46 5_B2	Y	1.6439	1.6500	0.0300	-0.0300	-0.0061	-
☐ 47 5_B2	Y	1.9527	1.9600	0.0100	-0.0100	-0.0073	-
☐ 48 5_C2	Y	2.8835	2.8900	0.0300	-0.0300	-0.0065	-
☐ 49 5_B2	Y	2.5748	2.5800	0.0100	-0.0100	-0.0052	-
☐ 47 Perp to body surf ref	GDT Perp	0.0004	0.0000	0.0050		0.0004	-
☐ 49 Parallel to 47 ref	GDT Par	0.0002	0.0000	0.0060		0.0002	-
☐ 50 5_B2	Y	1.3003	1.3100	0.0300	-0.0300	-0.0097	-
☐ 51 5_C2	Y	3.2250	3.2300	0.0300	-0.0300	-0.0050	-
☐ 52 5_B3	X	-2.4426	-2.4500	0.0300	-0.0300	0.0074	-
☐ 53 5_B4	X	-4.3645	-4.3700	0.0300	-0.0300	0.0055	-
☐ 54 5_B6	X	-9.4999	-9.5000	0.0300	-0.0300	0.0001	-
☐ 55 5_B6	X	-9.7224	-9.7200	0.0300	-0.0300	-0.0024	-
☐ 56 5_B6	X	-11.1979	-11.2000	0.0300	-0.0300	0.0021	-
☐ 57 5_B8	Y	1.5869	1.5900	0.0300	-0.0300	-0.0031	-
☐ 58 5_C8	Y	3.6167	3.6200	0.0300	-0.0300	-0.0033	-
☐ 59 5_B8	Y	1.8622	1.8700	0.0300	-0.0300	-0.0078	-
☐ 60 5_C8	Y	3.3379	3.3400	0.0300	-0.0300	-0.0021	-
☐ 61 5_D6	Z	-0.9827	-0.9900	0.0300	-0.0300	0.0073	-
☐ 62 5_B8	Y	2.2027	2.2100	0.0300	-0.0300	-0.0073	-
☐ 63 5_C8	Y	3.0015	3.0100	0.0300	-0.0300	-0.0085	-
☐ 90 3_B5	Z	0.2209	0.2150	0.0300	-0.0300	0.0059	-
☐ 91 3_B2	CartDist	0.6221	0.6200	0.0050	0.0000	0.0021	-



Part Number E4706-1

Serial # 37729-001

Time 7:16:20 pm

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- ->
☐ 94 4_D2	Z	1.2229	1.2200	0.0100	-0.0100	0.0029	-
☐ 95 4_D2	Z	1.2229	1.2200	0.0100	-0.0100	0.0029	-

Manually Inspected Features

64	2_B3	R0.28 typ.	R.28 TYP.
65	3_C8	R0.25 typ.	R.25 TYP.
66	3_B5	R0.06 typ.	R.06 TYP.
67	3_B2	R0.14 typ.	R.130 TYP.
68	4_D4	R0.22	R.220 TYP.
69	5_D7	R0.25 min.	R.250 TYP.
70	5_C5	R0.28 4 pl.	R.280 TYP.
71	5_A8	15.25 ref.	15.252
72	2_A8	Deburring per note 5	PASSED
73	2_A8	Surface finish per note 8	PASSED
74	2_A8	Relief parallel to outside face	PASSED
75	2_A3	0.20 dim	.201/.202
76	2_D3	0.32 dim	.315
85	2_B4	R0.28 typ.	R.28 TYP.
86	3_C5	0.20 wall	.198/.201
87	3_B8	0.23 wall typ.	.225/.227

Customer Dart Aerospace

Customer P.O. PO30760

Drawing # E4706

Drawing rev B

Part Number D4706-1

E.C.O. -

Part Name Support Bracket

Material Alum. Alloy 7075-T7351 per ASTM B209

Serial # 006

Inspected by Cliff Smith

Job # 37729

Signature:



ACCEPTED



Overall Result

All Characteristics:

65

Out of tolerance:

0

Over Warning Limit:

0

Not Calculated:

0

Comment: Side 1

MATERIAL: 7075-T7351 PER ASTM B209
REF. 'CONSTELLUM' LOT # 9332688

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- ->
☐ Datum Face 1 Flat ref	GDT Flat	0.0024	0.0000	0.0050		0.0024	-
☐ 1 2_D2	Y	8.9462	8.9500	0.0300	-0.0300	-0.0038	-
☐ 2 2_D2	Y	-8.8356	-8.8400	0.0300	-0.0300	0.0044	-
☐ 3 3_C1	A	95.0176	95.0000	0.5000	-0.5000	0.0176	-
☐ 4 2_D2	Y	8.8326	8.8400	0.0300	-0.0300	-0.0074	-
☐ 5 3_C1	A	94.9993	95.0000	0.5000	-0.5000	-0.0007	-
☐ 6 2_D8	Y	8.9170	8.9201	0.0300	-0.0300	-0.0031	-
☐ 7 2_D8	Y	8.8067	8.8099	0.0300	-0.0300	-0.0032	-
☐ 8 3_C2	A	95.0072	95.0000	0.5000	-0.5000	0.0072	-
☐ 9 3_C5	R	0.6298	0.6300	0.0300	-0.0300	-0.0002	-
☐ 10 2_D2	X	-0.1145	-0.1200	0.0300	-0.0300	0.0055	-
☐ 11 2_D3	X	-0.4147	-0.4200	0.0300	-0.0300	0.0053	-
☐ 12 2_D3	X	-1.5038	-1.5100	0.0300	-0.0300	0.0062	-
☐ 13 2_D6	X	-9.7492	-9.7500	0.0300	-0.0300	0.0008	-
☐ 14 2_B8	ResEle	-15.2501	-15.2500	0.0300	-0.0300	-0.0001	-
☐ 15 2_D8	Y	8.6551	8.6500	0.0300	-0.0300	0.0051	-
☐ 16 2_B2	Y	0.9527	0.9500	0.0300	-0.0300	0.0027	-
☐ 18 2_D2	Y	8.5238	8.5200	0.0300	-0.0300	0.0038	-
☐ 19 2_D2	Y	8.5233	8.5200	0.0300	-0.0300	0.0033	-
☐ 20 2_B6	X	-9.4989	-9.5000	0.0300	-0.0300	0.0011	-
☐ 21 2_B6	X	-11.4181	-11.4200	0.0300	-0.0300	0.0019	-
☐ 22 2_C8	Y	5.5620	5.5600	0.0300	-0.0300	0.0020	-
☐ 23 2_C8	Y	5.8125	5.8100	0.0300	-0.0300	0.0025	-
☐ 24 2_D8	Y	6.8719	6.8700	0.0300	-0.0300	0.0019	-
☐ 25 2_D8	Y	7.1223	7.1200	0.0300	-0.0300	0.0023	-
☐ 25 2_C8	Y	5.9440	5.9450	0.0100	-0.0100	-0.0010	-
☐ 26 2_D8	Y	6.7436	6.7450	0.0100	-0.0100	-0.0014	-
☐ 27 2_D6	X	-9.7221	-9.7200	0.0300	-0.0300	-0.0021	-
☐ 28 2_D6	X	-10.2405	-10.2300	0.0600	-0.0600	-0.0105	-
☐ 29a 2_D4	X	-4.3625	-4.3700	0.0300	-0.0300	0.0075	-
☐ 29b 2_D4	X	-4.3634	-4.3700	0.0300	-0.0300	0.0066	-
☐ 29c 2_D4	X	-4.3624	-4.3700	0.0300	-0.0300	0.0076	-



Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
☒ 23 Perp to body surf ref	GDT Perp	0.0018	0.0000	0.0050		0.0018	-
☐ 24 Parallel to 23 ref	GDT Par	0.0013	0.0000	0.0050		0.0013	-
☐ 30a 3_C8	Z	-1.0341	-1.0400	0.0300	-0.0300	0.0059	-
☐ 30b 3_C8	Z	-1.0351	-1.0400	0.0300	-0.0300	0.0049	-
☐ 30c 3_C8	Z	-1.0346	-1.0400	0.0300	-0.0300	0.0054	-
☐ 30d 3_C8	Z	-1.0350	-1.0400	0.0300	-0.0300	0.0050	-
☐ 30e 3_C8	Z	-1.0344	-1.0400	0.0300	-0.0300	0.0056	-
☐ 30f 3_C8	Z	-1.0338	-1.0400	0.0300	-0.0300	0.0062	-
☐ 30g 3_C8	Z	-1.0357	-1.0400	0.0300	-0.0300	0.0043	-
☐ 31 4_C5	D	0.4377	0.4375	0.0005	-0.0005	0.0002	-
☐ 32 4_C4	X	-10.6928	-10.6900	0.0300	-0.0300	-0.0028	-
☐ 33 4_A4	D	0.5626	0.5625	0.0005	-0.0005	0.0001	-
☐ 34 4_C4	X	-10.6930	-10.6900	0.0300	-0.0300	-0.0030	-
☐ 35 4_C6	R	0.7254	0.7300	0.0300	-0.0300	-0.0046	-
☐ 36 4_C8	ResEle	1.9227	1.9300	0.0300	-0.0300	-0.0073	-
☐ 37 4_C6	A	67.0265	67.0000	0.5000	-0.5000	0.0265	-
☐ 77 2_C2	Y	4.7420	4.7400	0.0300	-0.0300	0.0020	-
☐ 78 2_C2	Y	4.5397	4.5400	0.0300	-0.0300	-0.0003	-
☐ 79 2_B2	3d Dist	0.1967	0.2000	0.0300	-0.0300	-0.0033	-
☐ 80 2_B3	3d Dist	0.1962	0.2000	0.0300	-0.0300	-0.0038	-
☐ 81 2_B4	3d Dist	0.3419	0.3448	0.0300	-0.0300	-0.0030	-
☐ 82 2_C3	3d Dist	0.1371	0.1400	0.0300	-0.0300	-0.0029	-
☐ 83 2_C4	3d Dist	0.1976	0.2000	0.0300	-0.0300	-0.0024	-
☐ 84 2_D4	3d Dist	0.1898	0.2000	0.0300	-0.0300	-0.0102	-
☐ 86 3_C6	3d Dist	0.1994	0.2000	0.0300	-0.0300	-0.0006	-
☐ 88 3_C5	Z	0.2547	0.2500	0.0300	-0.0300	0.0047	-
☐ 89 3_C2	CartDist	1.0588	1.0600	0.0100	-0.0100	-0.0012	-
☐ 92 4_D2	Z	1.2541	1.2550	0.0100	-0.0100	-0.0009	-
☐ 93 4_D2	Z	1.2509	1.2550	0.0100	-0.0100	-0.0041	-
☐ 96 5_D8	3d Dist	0.1696	0.1692	0.0300	-0.0300	0.0003	-

Customer Dart Aerospace

Customer P.O. PO30760

Drawing # E4706

Drawing rev B

Part Number E4706-1

E.C.O. -

Part Name Support Bracket

Material Alum. Alloy 7075-T7351 per ASTM B209

Serial # 37729-006

Inspected by Cliff Smith

Job # 37729

Signature:



Overall Result

All Characteristics: 36
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: Side 2

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-- -->
☐ 38 4_D2	Z	-1.2605	-1.2600	0.0300	-0.0300	-0.0005	-
☐ top and bott surfs Parallel ref	GDT Par	0.0028	0.0000	0.0100		0.0028	-
☐ 39 4_B6	D	0.6251	0.6250	0.0005	-0.0005	0.0001	-
☐ 40 4_C3	X	-3.6372	-3.6400	0.0300	-0.0300	0.0028	-
☐ 41 4_D4	D	0.5003	0.5000	0.0005	-0.0005	0.0003	-
☐ 42 4_C3	X	-3.6374	-3.6400	0.0300	-0.0300	0.0026	-
☐ 42 4_D4	R	0.7268	0.7300	0.0300	-0.0300	-0.0032	-
☐ 43 4_D2	ResEle	1.8927	1.8900	0.0300	-0.0300	0.0027	-
☐ 44 4_D3	A	67.0172	67.0000	0.5000	-0.5000	0.0172	-
☐ 45 4_D2	ResEle	5.0780	5.0800	0.0300	-0.0300	-0.0020	-
☐ 46 5_B2	Y	1.6415	1.6500	0.0300	-0.0300	-0.0085	-
☐ 47 5_B2	Y	1.9502	1.9600	0.0100	-0.0100	-0.0098	---
☐ 48 5_C2	Y	2.8814	2.8900	0.0300	-0.0300	-0.0086	-
☐ 49 5_B2	Y	2.5721	2.5800	0.0100	-0.0100	-0.0079	---
☐ 47 Perp to body surf ref	GDT Perp	0.0007	0.0000	0.0050		0.0007	-
☐ 49 Parallel to 47 ref	GDT Par	0.0007	0.0000	0.0060		0.0007	-
☐ 50 5_B2	Y	1.2993	1.3100	0.0300	-0.0300	-0.0107	-
☐ 51 5_C2	Y	3.2219	3.2300	0.0300	-0.0300	-0.0081	-
☐ 52 5_B3	X	-2.4440	-2.4500	0.0300	-0.0300	0.0060	-
☐ 53 5_B4	X	-4.3646	-4.3700	0.0300	-0.0300	0.0054	-
☐ 54 5_B6	X	-9.4997	-9.5000	0.0300	-0.0300	0.0003	-
☐ 55 5_B6	X	-9.7225	-9.7200	0.0300	-0.0300	-0.0025	-
☐ 56 5_B6	X	-11.1979	-11.2000	0.0300	-0.0300	0.0021	-
☐ 57 5_B8	Y	1.5784	1.5900	0.0300	-0.0300	-0.0116	-
☐ 58 5_C8	Y	3.6085	3.6200	0.0300	-0.0300	-0.0115	-
☐ 59 5_B8	Y	1.8637	1.8700	0.0300	-0.0300	-0.0063	-
☐ 60 5_C8	Y	3.3393	3.3400	0.0300	-0.0300	-0.0007	-
☐ 61 5_D6	Z	-0.9829	-0.9900	0.0300	-0.0300	0.0071	-
☐ 62 5_B8	Y	2.2029	2.2100	0.0300	-0.0300	-0.0071	-
☐ 63 5_C8	Y	3.0017	3.0100	0.0300	-0.0300	-0.0083	-
☐ 90 3_B5	Z	0.2202	0.2150	0.0300	-0.0300	0.0052	-
☐ 91 3_B2	CartDist	0.6234	0.6200	0.0050	0.0000	0.0034	-



Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- ->
☐ 94 4_D2	Z	1.2248	1.2200	0.0100	-0.0100	0.0048	-
☐ 95 4_D2	Z	1.2221	1.2200	0.0100	-0.0100	0.0021	-

Manually Inspected Features

64	2_D3	R0.28 typ.	<u>R.28TYP.</u>
65	3_C8	R0.25 typ.	<u>R.25TYP</u>
66	3_B5	R0.06 typ.	<u>R.09TYP.</u>
67	3_B2	R0.14 typ.	<u>R.130TYP.</u>
68	4_D4	R0.22	<u>R.220TYP.</u>
69	5_D7	R0.25 min.	<u>R.250TYP.</u>
70	5_C5	R0.28 4 pl.	<u>R.280TYP.</u>
71	5_A8	15.25 ref.	<u>15.251</u>
72	2_A8	Deburring per note 5	<u>PASSED</u>
73	2_A8	Surface finish per note 8	<u>PASSED</u>
74	2_A8	Relief parallel to outside face	<u>PASSED</u>
75	2_A3	0.20 dim	<u>.201</u>
76	2_D3	0.32 dim	<u>.314</u>
85	2_B4	R0.28 typ.	<u>R.28TYP.</u>
86	3_C5	0.20 wall	<u>.199/.200</u>
87	3_B8	0.23 wall typ.	<u>.224/.226</u>